



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3890-041
Job Sheet 203112



Part No: D3890-041

Job Qty: 1 pcs

Part Name: Panel Wall - Sub-Component Of#D350-766-021



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 11/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev.B 17.06.13 Now outside process DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Purchasing	1 pcs	11/25/19		0.00	0.00	Purchasing - 1	DEC 0 3 2019
							Purchasing - 2	
							Purchasing - 3	
140	Packaging 2-1 - Receive - B4B	1 pcs	11/25/19		0.00	0.00	Packaging 2 - 1 - B4B	DEC 0 3 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S236906



Part: D3890-041

Job No: 203112

Serial No/Batch: S236906

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	1 pcs	11/25/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
160 Small Fab - 2 - B4B	1 pcs	11/25/19	0.00 0.33		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
165 QC 5	1 pcs	11/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
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					Packaging 3 - 19 - B4B	
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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/25/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

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DEC 17 2019

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DEC 17 2019

Part Op 110 - (Purchasing) ISSUE P/O: HBC45068 SUPPLIER: PLASTECH MANUFACTURE D3890-1 AS PER
Descriptions: DWG C OF C IS REQUIRED

140 - (Receive & Inspect for Damage & Mat'l Certs)

150 - (QC6- All purchased or subcontracted products)

160 - (Small Fab) 1- Install gasket as per dwg with 3M 1300 adhesive (note 8) Batch: _____

165 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

K2 Plus 11 Nov 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3890-1P	Panel	1 Ea (1 ea)	110-Purchasing	
MLEXS.125-F60029-04	GE Plastics Lexan Sheet (Dark Grey)	3.6180 sf (3.618 ea)	110-Purchasing	
D3890-3	Gasket	2 pcs (2 ea)	160-Small Fab - 2 - B4B	

S236901

S157065

f 137609

S240313

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3890-1P	1	0	0
	MLEXS.125-F60029-04	4	1,138	0
160-Small Fab - 2 - B4B	D3890-3	2	2	0

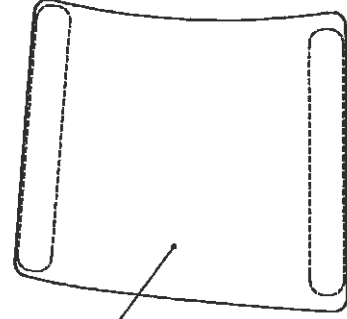
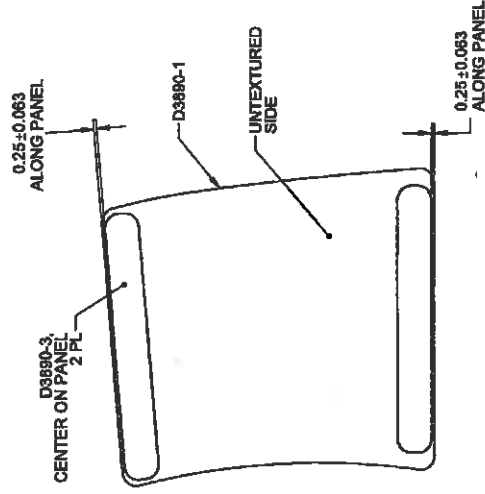
Part Specifications

Specifications could not be found.

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PARTS LIST

ITEM	QTY	PIN	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

TEXTURED
SIDE

D3890-041 PANEL, SIDE

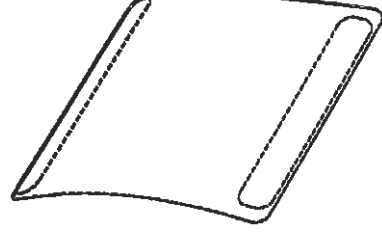
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.48 lbs
 - 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

A	NEW ISSUE	DESCRIPTION	CP	BY	DATE
REV.					
DESIGN	01	DART AEROSPACE LTD			
DRAWN	01	HAMMERSBURY, ONTARIO, CANADA			
CHECKED	PH	DRAWING NO.			REV. A
MFG. APPR.	01	D3890			SHEET 1 OF 4
APPROVED	01	TITLE			SCALE
DE APPR.	01	PANEL, SIDE			NTS
DATE	09.05.01				

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RELEASED
11/07/16

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 201112-465
137171



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Lead hand / Supervisor			
		QC / QA Coordinator			



128 WALGREEN ROAD
CARP. ON KOA 1LO
PHONE-613-831-4640
FAX-613-831-4624

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: December 3, 2019

YOUR PURCHASE ORDER: PO HB045068

OUR INVOICE NO: 37811

LINE ITEM # 1

QUANTITY: 2

DESCRIPTION: SIDE PANEL PER DWG D3890-1P REV A.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D3890-1P REV 1.0 USING DWG D3890-1P REV A.

Note: USED 1 SHEET - 24 SF OF F60029 LEXAN SHEET – HEAVY HAIRCELL – DARK GREY
GY3778. 0.125 IN THICK. BATCH# S152065-1.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS
AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

A handwritten signature in black ink, appearing to read 'Mark Perry', is written over a horizontal line.

MARK PERRY, M.ENG.
PRESIDENT

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Form 1: Part Number Accountability[illegible]

Form 2: Product Accountability – Raw Material, Specifications and Special Process(es), Functional Testing

Sheet 1 of 1

[illegible]

SAE AS9102 First Article Inspection Form

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

Sheet 1 of 2

1. Part Number				2. Part Name			3. Serial Number	4. FAI Report
D3890-1P				SIDE PANEL			2019-001	FAIR-D3890-1P REV A
Characteristic Accountability				Inspection / Test Results				
5. Char No.	6. Reference Location	7.Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.	
1	8A-SH2, Eng. Note 1		MAKE FROM D3890-1F	NOTED				
2	8A-SH2, Eng. Note 2		FINISH: NONE	NOTED				
3	8A-SH2, Eng. Note 3		TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	NOTED				
4	8A-SH2, Eng. Note 4		UNITS: INCHES UNLESS OTHERWISE NOTED	NOTED				
5	8A-SH2, Eng. Note 5		BREAK SHARP EDGES: NONE	ALL EDGES SCRAPPED				
6	8A-SH2, Eng. Note 6		IDENTIFICATION: NONE	NOTED				
7	8A-SH2, Eng. Note 7		WEIGHT: 2.4 Lbs.	3 LBS			PLASTECH WEIGH SCALE IS +/- 1 LB	
8	8A-SH2, Eng. Note 8		THERMOFORM USING MOULD DT9489 PER QSI 022.	NOTED AND FOLLOWED.				
9	8B-SH2		23.2 REF	23.25				
10	6D-SH2		21.9 REF	21.8				
11	5C-SH2		TEXTURED SIDE	NOTED AND FOLLOWED.				
12	4C-SH2		R30 REF	R30			THIS DIMENSION IS CONTROLLED BY MOULD DT9489.	
13	4A-SH2		2.3 REF	2.2			THIS DIMENSION IS CONTROLLED BY MOULD DT9489.	

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number D3890-1P				2. Part Name SIDE PANEL		3. Serial Number 2019-001	4. FAI Report FAIR-D3890-1P REV A
Characteristic Accountability				Inspection / Test Results			
5. Char No.	6. Reference Location	7.Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non-Conformance Number	14. Remarks.
14	8A-SH3, Eng. Note 1		MATERIAL: F60029 LEXAN SHEET – HEAVY HAIRCELL TEXTURE / DARK GREY. F60029 LEXAN, 0.125 THICK, GY3778 COLOR (DART SPEC. MLEXS.125-F60029-04)	CHECKED			Material supplied by customer _ Dart Material MLEXS.125-F60029-04 batch # S185915
15	7D-SH3		3.73	3.7			
16	7D-SH3		R228	R228			THIS DIMENSION IS CONTROLLED BY MOULD DT9489.
17	7C-SH3		23.78	23.95			
18	4D-SH3		R1.00 TYP	R1.0			
19	4C-SH3		R53	R53			THIS DIMENSION IS CONTROLLED BY MOULD DT9489.
20	4C-SH3		22.26	22.25			THIS DIMENSION IS CONTROLLED BY MOULD DT9489.
21	6B-SH3		20.88	20.75			
22	6B-SH3		21.91	21.95			
The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.							
12. Prepared By Mark Perry, Plas-Tech Fabrications						13. Date 12-02-2019	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045068



Supplier: PTF001-VC
Plas-Tech Fabrications
128 Walgreen Road
Ottawa
ON
K0A 1L0 Canada
Phone: 613-831-4640
Fax: 613-831-4624

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045068
PO Date: 11/11/19
Due Date: 12/3/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203112	D3890-1P	D3890 Rev.A			Panel : Various STC's As Per Dwg D3890 Rev. A	Firmed X2	-	12/3/19	2 Ea	0 Ea	2 Ea	\$296.25/Ea	\$592.50
Grand Total:														\$592.50

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Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Plex 12/3/19 1:01 PM dart.lussier.patrick

Plas-Tech Fabrications Inc.

128 Walgreen Rd
Stittsville, Ont
K0A 1L0
Ph: 613-831-4640
Fx: 613-831-4624

Packing Slip

Packing Slip No.:
Date:
Page:

37811
Dec 02, 2019

Sold to:		Ship to:	
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 POHB045068	
Order No.: 23034		Sold By: Mark Perry	
Shipped By:		Ship Date: Dec 02, 2019	
Tracking No.:			

Item No.	Unit	Description	Quantity
Misc	Each	Drawing# D3890-1P Rev A. Side Panel.	2
RECEIVED DEC 03 2019 DART AEROSPACE LTD.			
Comment: Thank you for your order.			